

Work Order ID 130260-2

March-02-15 11:40:42 AM

130260

Page 1

Item ID: D4682-045

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 3/02/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/06/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4682

C

110

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per dwg D4682-5

prog rev: C

dwg rev: C

2-Deburr if required

0.00

0.00

2

0

Jm 15-3-6

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

2

0

Jm 15-3-6

SCRAP

design change

DAS
9
9-89

1509/15

Work Order ID 130260

130260

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Item ID: D4682-045 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 3/02/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Form as per dwg D4682								

150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

MAR 05 2015

15/03/12

DAS
9
9-89

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130260

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Item ID: D4682-045 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 3/02/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: _____	0.00				1		15-03-24	MAL
Large Fab	Memo	0.00							
	1- Weld hardcoat as per dwg and QSI004								
	2- Weld shim to wearplate as per dwg and QSI004 A/R s.s. rod Batch #: <u>M123823</u>								
170 *170* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00				①	15-03-24		DAS 9 9-89
Quality Control	Memo	0.00							
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00				①	15-03-24		DAS 9 9-89
Quality Control	Memo	0.00							

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Packaging

1 CN 15-03-24

① 15-03-24

DAS
9
9-89

Work Order ID 130260

130260

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March-02-15 11:40:42 AM

Item ID: D4682-045 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Assembly
Start Date: 3/02/15 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/06/15 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

20150318
SJA

Picklist Print

Page 1

March-02-15 11:40:42 AM

Work Order ID: 130260

130260

Parent Item: D4682-045

D4682-045

Parent Item Name: Wearplate Assembly

Start Date: 3/02/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM IPP REV:B
13.11.14 AS PER DWG REV.B DD VERF:JLM IPP REV:C 14.11.24
AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4682-9		Manufactured	No				Each	15.0000		2			
---------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

D4682-9

Wearplate Shim

B130054 x2

Location

Loc Qty

Loc Code

prelim

3

122377

3

WA002

12

126934

12

M304S18GA

Purchased

No

110

sf

535.6756

2.066

(3)

M304S18GA

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

535.6756

124572

11.334

125552

19.75

M126647

22.014

M128254

17.4387

M128435

27

M128864

31.5964

M129530

34.6667

M130345

11.1667

M130923

86.0424

M131384

274.6667

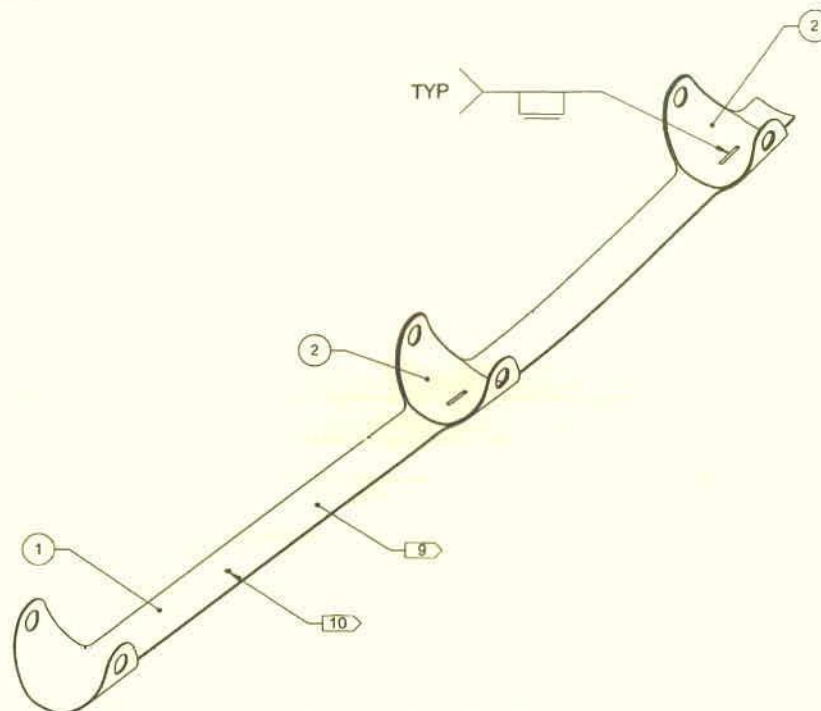
x2

15-03-24 MAL

Jm 15-3-6

131384

ITEM	QTY -045	P/N	DESCRIPTION
	X	D4682-045	WEARPLATE ASSY
1	1	D4682-5	WEARPLATE
2	2	D4682-9	WEARPLATE SHIM



D4682-045 WEARPLATE ASSY

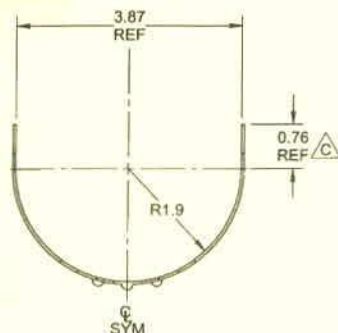
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.30 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\phi 0.188$ AFTER APPLYING TEXTURED COATING

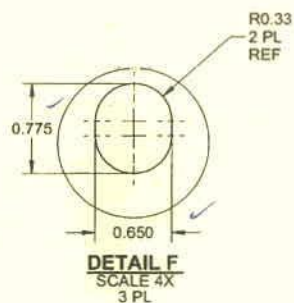
APPROVED

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4682	SHEET 2 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	14.07.29	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DART AEROSPACE USA, INC. WRITTEN PERMISSION.	

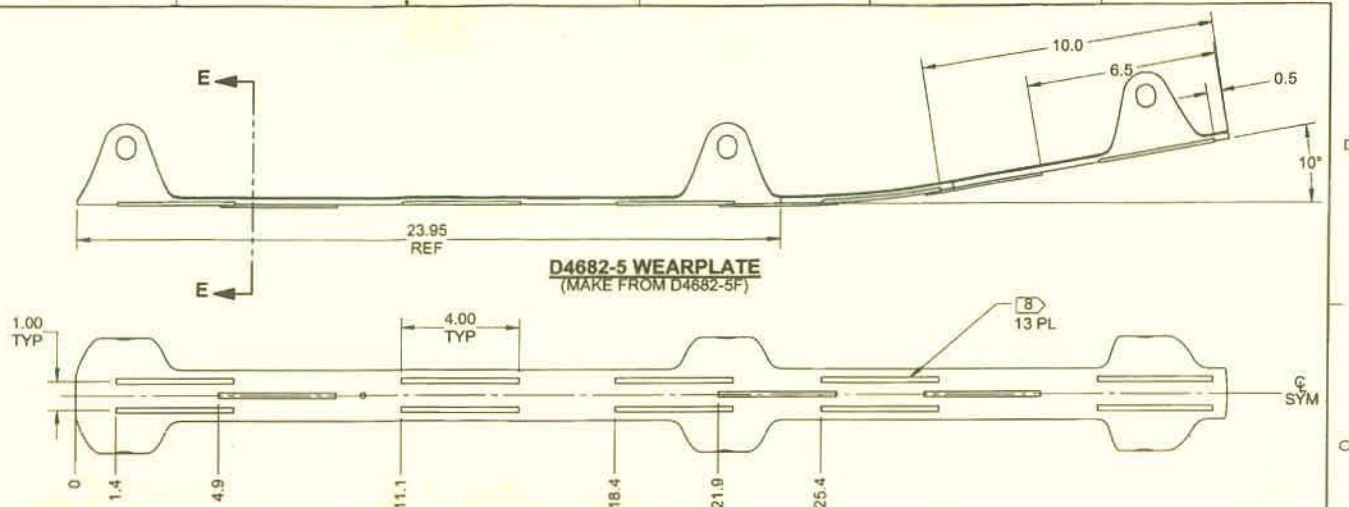
RELEASED
2014-11-20



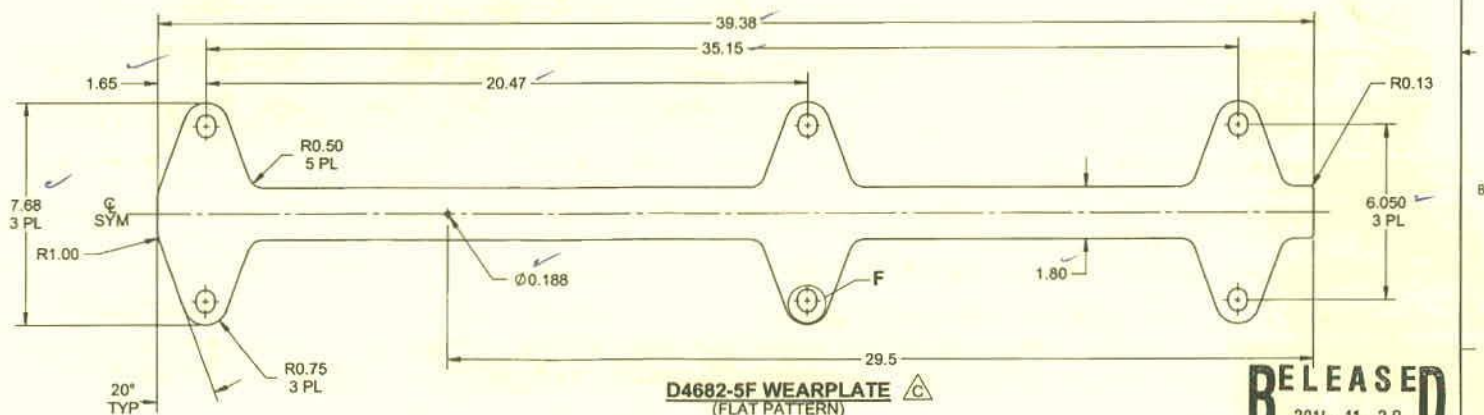
SECTION E-E
SCALE 2X



DETAIL F
SCALE 4X
3 PL



D4682-5 WEARPLATE
(MAKE FROM D4682-5F)



D4682-5F WEARPLATE
(FLAT PATTERN)

RELEASED
2014-11-20

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs
- 8) WELDING: PER QSI 004. APPLY LAYER OF 2059B HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
- 9) IT IS ACCEPTABLE TO OVERBEND D4682-5 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

APPROVED

DESIGN	AP
DRAWN	AP
CHECKED	ML
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.07.29

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO
D4682
TITLE
WEARPLATE ASSY
REV. C
SHEET 5 OF 8
SCALE
NTS

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

